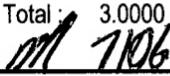
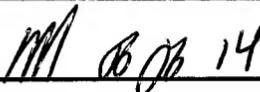
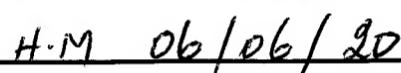


Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 27522		
Estimate Number	: 10104		
P.O. Number	: NIA	Part Number	: D2012107
This Issue	: 6/13/2006 S.O. No. : NIA	Drawing Number	: D2012-107 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/12/2006 Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 25483	Material	: NIA
Written By	: SEE COMMENT BELOW	Due Date	: 6/30/2006
Checked & Approved By	: 	Qty:	100 Um: Each
Comment	: Est: D 01.11.08 Re-format, Drawing to Rev. C SM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	WATER JET	FLOW WATER JET	
			
	Comment: FLOW WATER JET  OB 06 14 (100)		
2.0	M304S16GA	304/316 .063 Sheet	
			
	Comment: Qty.: 0.0300 sf(s)/Unit Total: 3.0000 sf(s) 304/316 .063 Sheet  7106  OB 14		
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached		
4.0	QC6	DIMENSIONAL CHECK	
			
	Comment: DIMENSIONAL CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr  M.F. 06-06-19		
6.0	BRAKE NC	NC BRAKE	
			
	Comment: NC BRAKE Form on press using DT8242 as per Dwg D2012-107  H.M 06/06/20		

Date: Tuesday, 6/13/2006 3:28:56 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27522

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QCS

SECOND CHECK



Comment: SECOND CHECK

SB 06/06/20

(100)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

See Attached.

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/21

(100)

Job Completion



U 06.06.21

Date: Monday, 6/12/2006 3:43:15 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLEVIS  
 Job Number : 27522  
 Estimate Number : 10104  
 P.O. Number : Part Number : D2012107  
 This Issue : 6/12/2006 S.O. No. : Drawing Number : D2012-107 REV. C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : C  
 Previous Run : 25483 Material :  
 Written By : Due Date : 6/30/2006 Qty: 100 Um: Each  
 Checked & Approved By : *JA 06.06.13*  
 Comment : Est: D 01.11.08 Re-format, Drawing to Rev. C SM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O:

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per DXF file

Material release note is required.

*Water Plot*  
*Dwg Rev: C*

*Proj Rev: C*

*M 7106*

*MA 06 06 14 (100)*

2.0 D2012107F Clevis

*QC2*



Comment: Qty: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

CLEVIS

*MA 06 06 14 (100)*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*QC8*

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

*06-06-15 (100)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:43:15 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27522

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

7.0

QC# 5

SECOND CHECK



Comment: SECOND CHECK

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST016

C700120106

(100)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

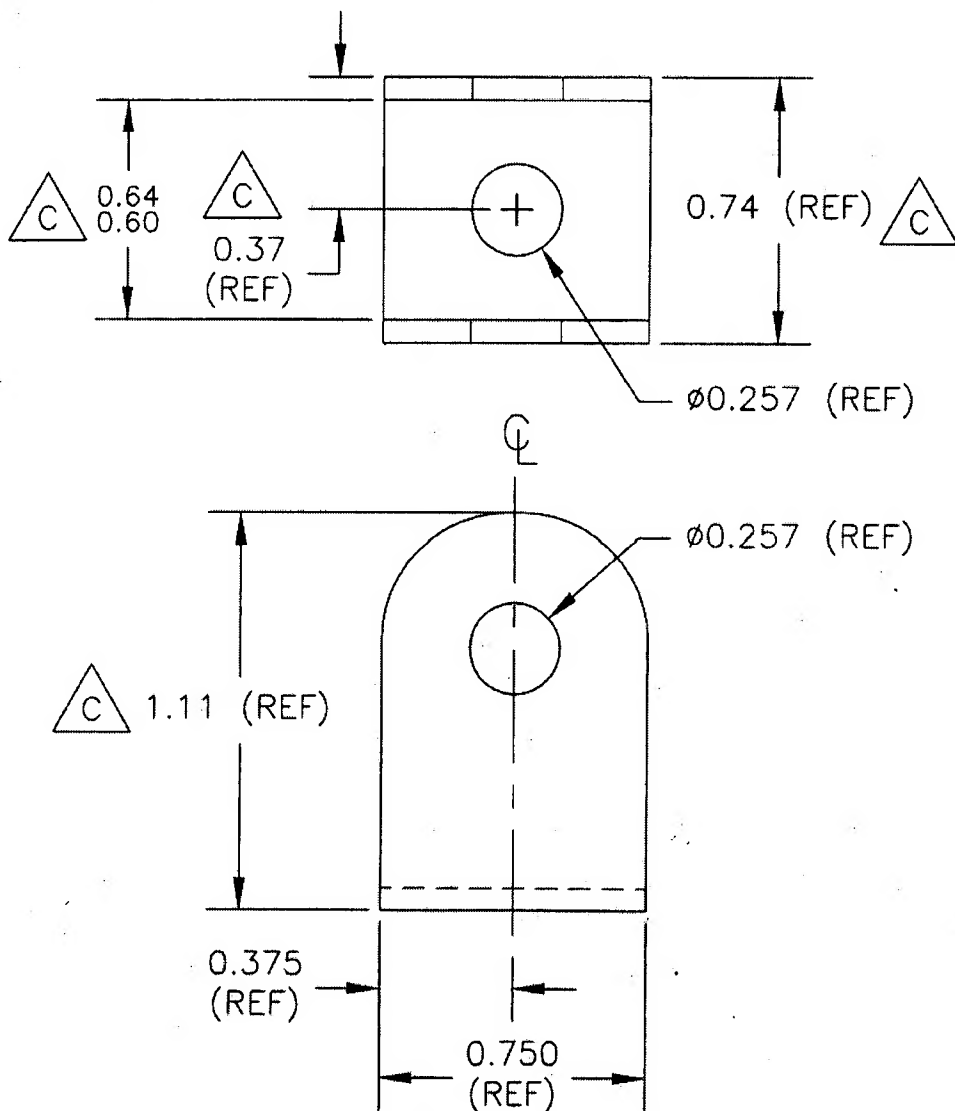
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED  
00.01.04 PS



MATERIAL: AISI 304/316 SS 0.063 THICK

USE 0.032 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

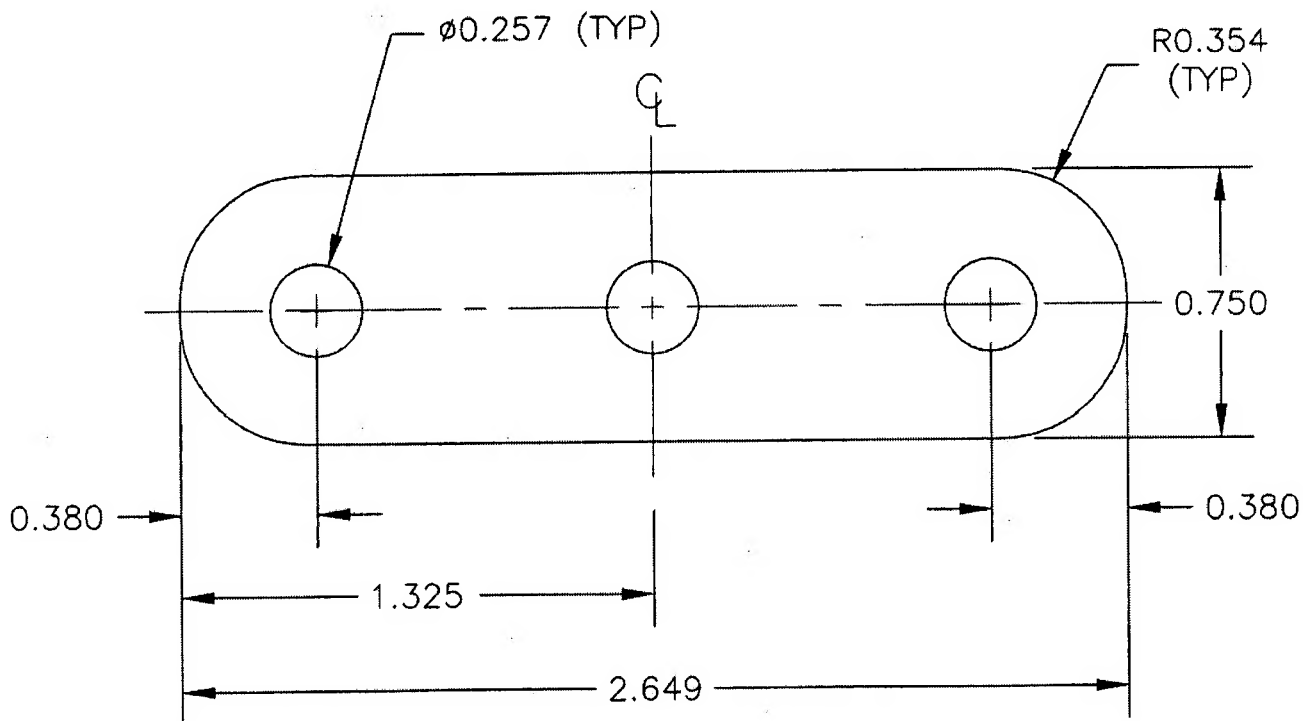
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27522



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED  
00-01-04 DS



D2012-107 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK  
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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NO. 27522

